

AMENDMENTS TO THE SPECIFICATION:

Kindly replace paragraph [0019] with the following amended paragraph:

The width of the ply is equal to the distance between the two boundaries. The ply is adjusted to a required length (L1). The front and rear edges form an angle $[(\alpha)]$ with the longitudinal direction of the ply. The angle $[(\alpha)]$ is generally between 15° and 65°.

Kindly replace paragraph [0021] with the following amended paragraph:

Each of the areas, respectively front (A) and rear (A'), consists of at least three parts in the form of a parallelogram with approximately equal sizes and forming gripping sectors. Each of these sectors is delimited by imaginary longitudinal lines (7, 8, 7', 8'). The number of gripping sectors is determined by the nature and width of the ply to be laid and are shared between a sector bordering the boundary forming an angle $[(\alpha)]$ with the ply edge and called the toe (1, 1'), a certain number of intermediate sectors and a sector bordering the boundary forming an angle $[(\pi - \alpha)]$ with the edge and called the heel (3, 3'). Fig. 1 illustrates the case where each of the front and rear areas is divided into three gripping sectors forming the toe, respectively front and rear (1 and 1'), the central gripping sector, respectively front and rear (2 and 2') and the heel, respectively front and rear (3 and 3').

Kindly replace paragraph [0025] with the following amended paragraph:

A laying form (104), generally cylindrical as shown diagrammatically in Fig. 9, supported by a frame (111), is disposed downstream of the conveyer. The diameter D1 of the shape of the laying form is determined so that the circumference $(\pi \times D1)$ is adapted to the size of the tire to be produced. A mechanical locking system (not shown) makes it possible to align the axis of the machine (MM') with the equatorial plane (EE') of the laying form. The laying form is driven in rotation about an axis (FF') by a positioning motor (not shown) making it possible to coil a precise length of ply determined for each sequence in the laying cycle. The laying form comprises a magnetic or pneumatic device (not shown) intended to make the front and rear areas adhere to the surface of the form.

Kindly replace paragraph [0028] with the following amended paragraph:

A conventional orientable cutting assembly (120) with a floating blade (not shown) and as described for example in the publication US 3 641 855 (incorporated by reference herein) or in the publication FR 1 220 265, is disposed at the head of the conveyer. The cutting assembly is oriented so as to form an edge oriented at an angle (α) with respect to the longitudinal axis of the conveyer. It makes it possible to make a cut between two cords of a continuous belt strip (B) without damaging the adjacent cords at the edge of the ply while tolerating an angular difference of the ply edge with respect to the theoretical angle $[(\alpha)]$ (α). Once the strip is cut, a belt ply (N) is obtained with a given length (L1), ready to be placed in the current cycle of the process. Lateral clamps (not shown) placed close to the cutting edge make it possible to keep firmly in position during the cutting operation the rear area of the ply intended to be laid in the cycle during the process and the front area of the ply whose laying will correspond to a subsequent cycle in the process.

Kindly replace paragraph [0033] with the following amended paragraph:

Fig. 6, 6A and Fig. 7 show respectively a partial front schematic view, a transverse section along A-A in Fig. 6 and a schematic plan view of a front transporter according to the method. An arm (204) is fixed by one of its ends to the motorised movable train (205) and through the other end supports a pivoting cross-member (209). An indexable fixing plate (206) fixes the cross-member (209) by its center to the arm (204). This fixing plate, fixed to the cross-member (209), comprises a central attachment point (207) disposed at the middle of the cross-member and a set of attachment points (208) predisposed so as to be able to fix the cross-member to the arm with an orientation substantially parallel to the edge of the ply and forming an angle $[(\alpha)]$ (α) with the machine axis (MM'), making it pivot about an axis (VV') perpendicular to the plane of the conveyer and passing through the center of the central attachment point (207).

Kindly replace paragraph [0034] with the following amended paragraph:

The cross-member (209) supports two non-corrected gripping assemblies (202 and 203) and a gripping assembly (201) equipped with a ply edge corrector (230). These components can comprise one or more pneumatic suckers (210), (211) and (212, 213 and 214) or a magnet (215). Each gripping assembly is equipped with a raising and lowering cylinder (216, 217 and 218) for putting the suckers in contact with the top part of the ply. It will be noted that the gripping assembly (201) gripping the toe (1, 1') comprises several suckers (212, 213 and 214) as well as a magnet (215) falling or rising under the action of a pneumatic cylinder (219). This device grips the tapered part of the toe at several points so as to firmly hold this sector of the ply which would otherwise be liable to undergo significant movements.

Kindly replace the paragraph [0050] with the following amended paragraph:

These two configurations make it necessary to compensate for some of the differences between the large and small diameters. To obtain this result, an unwound length of the belt ply (L_1) is determined close to the smallest circumference (~~$\alpha \times D_1$~~) ($\pi \times D_1$) and, by longitudinally moving the transporters in opposite directions, the ply is stretched so as to bring its length to a judiciously chosen value (L_2), such that the ratio $k = L_2/L_1$ is between 1 and D_2/D_1 . This coefficient k is determined experimentally according to the nature of the fabric and the magnitude of the curve. The ply edges are then aligned by adding to the correction values determined by the analysis of the angular geometries measured for each of the front and rear edges a predetermined value for compensating for the angular variations introduced by the curve and the tensioning of the ply.